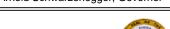
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

69.28 File #:

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-014804 Address: 333 Burma Road **Date Inspected:** 02-Jun-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1800 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes Li Yang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

**Bridge No:** 34-0006 **Component:** OBG

#### **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**OBG** Assembly Yard

7DW

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 022 located at OBW8A counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR13212 procedure.

7CW+7DW

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 013 located at EP059-001 counter weight side of segment. Welder is identified as Mr. Lu Xiaolin (067079). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR12992 procedure.

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 014 located at EP059-001 counter weight

### WELDING INSPECTION REPORT

(Continued Page 2 of 3)

side of segment. Welder is identified as Mr. Lu Xiaolin (067079). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR12993 procedure.

9AW+9BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW9B cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW9B cross beam side segment. Welder is identified as Mr. Zhang Quanfa (066326). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at OBW9B cross beam side segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW9B bottom plate splice of segment. Welder is identified as Mr. Zhang Quanfa (066038). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

8AW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 023 located at OBW8 counter weight side of segment. Welder is identified as Mr. Wang Bing (048696). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2232-Tc-U4b-F-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 023 located at OBW8 counter weight side of segment. Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 023 located at OBW8 counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 045 located at SEG043A cross beam side of segment. Welder is identified as Mr. Ni Leijiang (037723). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1560 procedure.

Y Location of repairs areas by above noted welder (037723) is located at 610 and 790mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.





# **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer